

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71540

Wednesday, July 06, 2011 11:27:45 AM



Page 2

Item ID: D3622-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Ball Stud

Start Date: 7/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 020

0.00



Packaging

Memo

0.00

Packaging

4/2/12 (21)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/12MF
11-07-12

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 11:27:43 AM

Page 1

Work Order ID: 71540



Parent Item: D3622-1



Parent Item Name: Ball Stud


Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500  303 HEX BAR .500		Purchased	No			100	f	73.4300	0.108	2.273684			



SA 11/7/7

Location

Loc Qty

Loc Code

MAT037

73.43

109778

73.43

2.3 Pt

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71540
Description: Ball Stud		Part Number:	D3622-1
Inspection Dwg: D3622 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	.567	/		SA-9	
0.50	+/-0.030	.498	/			
Ø0.394	+/-0.010	Ø.395	/		SA-5	
Ø0.310	+/-0.010	Ø.315	/			
Ø0.215	+/-0.010	Ø.217	/			
0.155	+/-0.010	.155	/			
0.313	+/-0.010	.313	/			
0.478	+/-0.010	.478	/			
0.630	+/-0.010	.630	/			
0.125	+/-0.010	.130	/			
0.563	+/-0.010	.563	/			
1.19	+/-0.030	1.191	/			
0.3125-24UNF-3A	+0.000/-0.072		/			
M.O.W.	Min = 0.3336 Max = 0.3363	.3345	/		SA-5	

SA
 11/7/7
 N/A

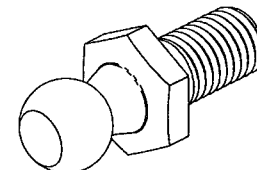
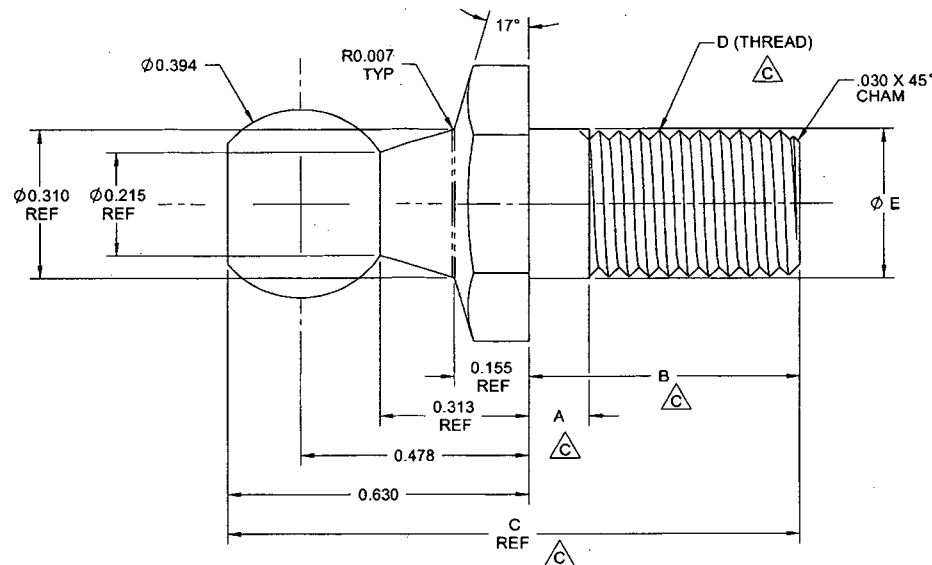
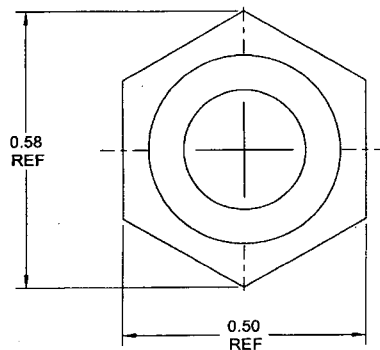
Measured by:	SA
Date:	11/7/7

Audited by:	R
Date:	11-7-11

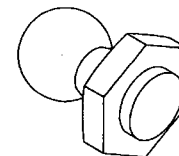
Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ	

8 7 6 5 4 3 2 1



D3622-1 BALL STUD SHOWN



D3622-11 BALL STUD SHOWN

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E	
						MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71546
CL1107106

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE



RELEASED
R 2010-09-23

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3622	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BALL STUD	NTS
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1